

Date: Monday, 4/23/2007 1:52:32 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 31991	
Estimate Number : 12735	
P.O. Number : <i>N/A</i>	Part Number : D353521
This Issue : 4/23/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3535 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision : <i>A B</i> <i>RH</i> 07-04-25
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 4/30/2007 Qty: <i>24</i> Um: Each
Checked & Approved By : <i>[Signature]</i> 07-04-26	
Comment : Est Rev: A New Issue 07-02-15 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	*304/316 .040 Sheet
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Comment: Qty.: 0.9371 sf(s)/Unit Total : 18.7425 sf(s)  
304/316 .040 Sheet  
(M304S20GA)

Batch: *M101463*

SAD 07/04/29

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D3535  
Dwg Rev: *B*  
Prog Rev: *B*

2-Deburr if necessary

SAD 07/04/29  
*[Signature]* 07/04/29(1) SCRAP  
*[Signature]*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/04/29 (23)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*[Signature]* 07/04/30 23

5.0	BRAKE NC	NC BRAKE
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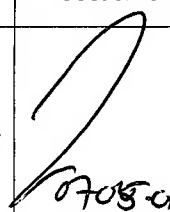
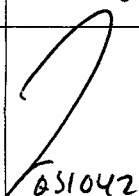



Comment: NC BRAKE  
Form bend & joggle as per Dwg D3535 using DT8261 & DT8326

SAS 07/05/01 (23)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 19 Date: 07/05/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070501	20	1 part scrap Machine cut too much off of one side.	 QS1042	Destroy, no replace	SB 07/04/30	 070501	 QS1042	 070501

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:32 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31991

Part Number: D353521

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



07-05-01 (23)



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



M101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

07-05-03

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M-L



(23X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/05/04

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(23X)

Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: EP-15

M-L 07/05/04

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(23)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/04

Job Completion



07-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

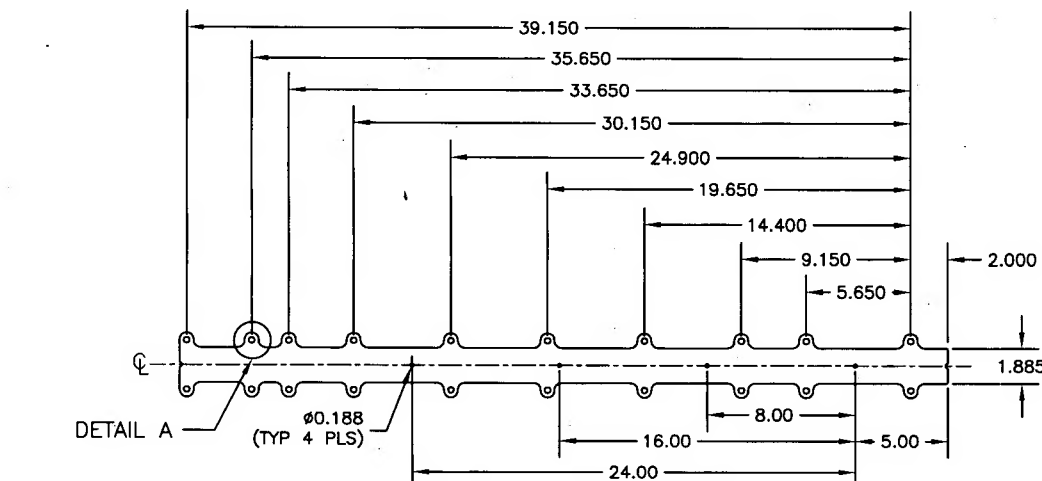
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

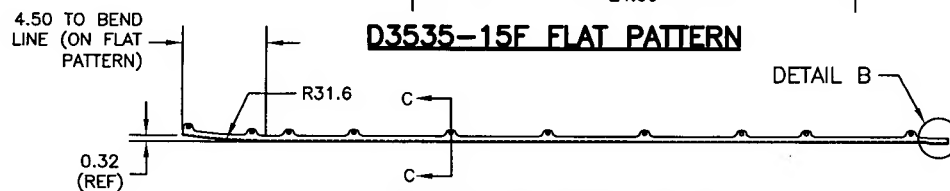
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

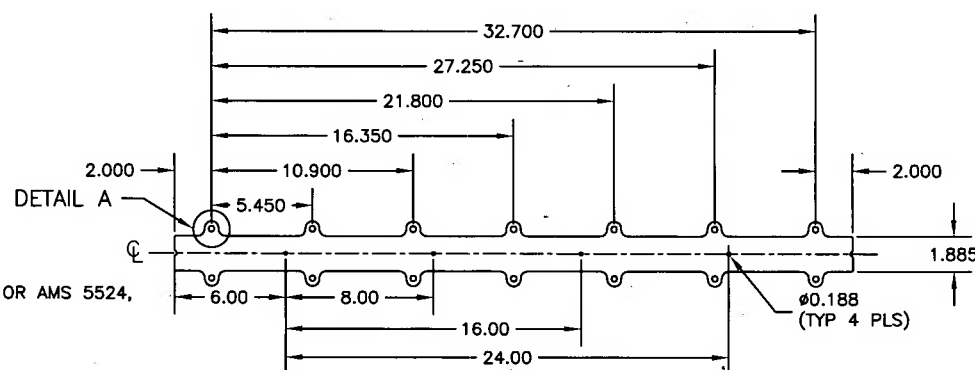


**D3535-15F FLAT PATTERN**

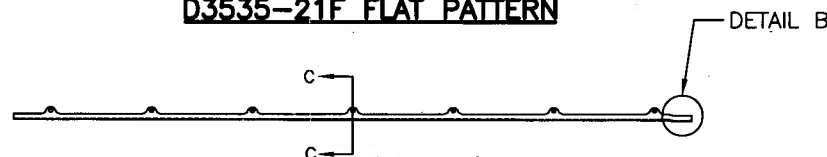


**D3535-15 BEND DETAIL**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31991



**D3535-21F FLAT PATTERN**



**D3535-21 BEND DETAIL**

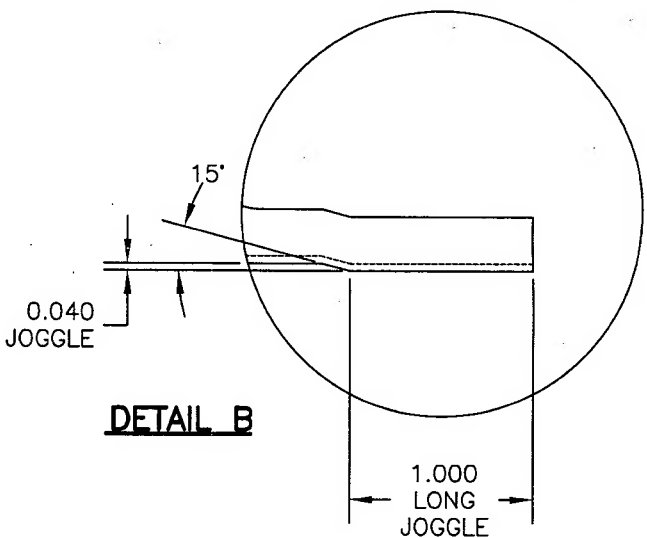
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

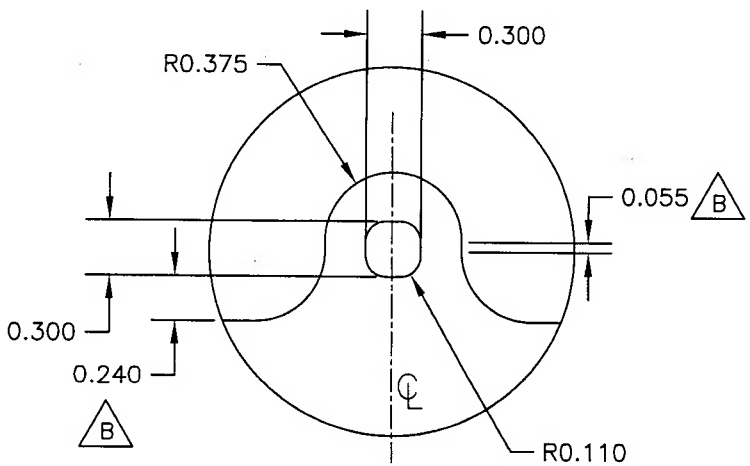
DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE USA, INC.</b>	REV. B
CHECKED	APPROVED	DRAWING NO. <b>D3535</b>	SHEET 2 OF 7
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	SCALE <b>1:10</b>	

PRELIMINARY ISSUE

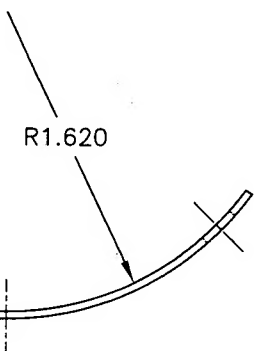
DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3535	REV. B
DATE 07.04.17		TITLE WEARSHOE	SHEET 7 OF 7
		SCALE 1:1	



DETAIL B



DETAIL A



SECTION C-C

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **31991**

DART AEROSPACE LTD		Work Order: 31991
Description: WEARSHOE		Part Number: D3535-21
Inspection Dwg: D3535 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 1.885	<del>±.008</del> 0.010	1.882	✓		Vern	
B 2.000	0.010	2.008	✓		Vern	
C 5.450	0.010	5.452	✓		Vern	
D 10.900	0.010	10.907	✓		Vern	
E 16.350	0.010	16.350	✓		M-T	
F 21.800	0.010	21.800	✓		M-T	
G 27.250	0.010	27.250	✓		M-T	
H 32.700	0.010	32.700	✓		M-T	
I 2.000	0.010	2.002	✓		Vern	
J 6.00	0.030	6.016	✓		Vern	
K 8.00	0.030	8.00	✓		Vern	
L 16.00	0.030	16.00	✓		Vern	
M 24.00	0.030	24.00	✓		Vern	
N Ø 0.188	+0.005/-0.001	Ø 0.188	✓		Vern	
O 0.038	0.010	0.036	✓		Vern	
P 0.300	+0.010	0.300	✓		Vern	
Q 0.300	+0.010	0.297	✓		Vern	
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 07/04/29	Date: 07/04/29	Date:	N/A
Rev	Date	Change	Revised by KJ/RF
		New Issue	Approved